

Work Order ID 145798

Monday, June 06, 2016 11:46:11 AM

145798

Page 1

Item ID: D4925-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: EAPS Mounting Plate

Start Date: 5/17/2016 Start Qty: 18.00

18

Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 18.00

18

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4925

D

105

0.00

105

Purchasing

Purchasing

34.50

Memo

ISSUE PO 32646
CUT PER DRWG D4925 REV.D

0.00

18

JUN 08 2016

DAS
13
9-89

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Packaging

Memo

0.00

18x SP/6 = 7-13

125

QC6- Inspect dimensions to drawing

0.00

125

QC

Quality Control

Memo

0.00

(13)

16-07-13

DAS
9
9-89

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Page 2

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Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Bend as per dwg

0.08

DAS
30
9-89

18

AUG 10 2016

DAS
36
9-89***130***

Brake NC

Memo

1.08

Brake NC

C'sink and bend tabs as per dwg

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.36

Quality Control

18

DAS
38
9-89
AUG 11 2016

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

1.80

Hand Finishing

18

2016/08/12
BEB

Work Order ID 145798

Monday, June 06, 2016 11:46:11 AM

145798

Page 3

Item ID: D4925-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: EAPS Mounting Plate

Start Date: 5/17/2016 Start Qty: 18.00

18

Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 18.00

18

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC7-Inspect Chemical Conversion Coat	0.00							
170						(18)			DAS 38 9-89
QC	Memo	0.18							
Quality Control									AUG 12 2016
175	QC5- Inspect part completeness to step on W/O	0.00							
175									
QC	Memo	0.36							
Quality Control									
180	Identify as per dwg & Stock Location: GA	0.00							
180									
Packaging	Memo	0.18							
Packaging									DAS 30 9-89
						(18)			SEP 08 2016

Work Order ID 145798

Monday, June 06, 2016 11:46:11 AM

145798

Page 4

Item ID: D4925-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: EAPS Mounting Plate

Start Date: 5/17/2016 Start Qty: 18.00

18

Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 18.00

18

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21 - Final Inspection - Work Order Release	0.00							
190									
QC	Memo	1.80							
Quality Control									

DAS
21
9-89~~SEP 0 8 2016~~DAS
21
9-89

SEP 0 8 2016

Picklist Print

Monday, June 06, 2016 11:46:10 AM

Page 1

Work Order ID: 145798

145798

Parent Item: D4925-1

D4925-1

Parent Item Name: EAPS Mounting Plate

Start Date: 5/17/2016

Required Date: 5/20/2016

Start Qty: 18.00

Required Qty: 18.00

Comments: IPP REV:A NEW ISSUE 13-08-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4925-1P		Purchased		No			Each	0.0000		18			
D4925-1P									**				
EAPS Mounting Plate													
M6061T6S.063		Purchased		No			sf	746.4000		77.68421			
M6061T6S 063									**				
6061-T6 .063 Sheet													

Location

Loc Qty

Loc Code

MAT021

410.4

M133511

2.8

M134377

4.9

M134830

402.7

TPI

336

M134496

192

M134604

144

18x SP/6-7-13

W

DART AEROSPACE LTD		Work Order:	145798
Description: EAPS Mounting Plate		Part Number:	D4925-1
Inspection Dwg: D4925	Rev: D	Page 1 of 1	

INSPECTION SHEET

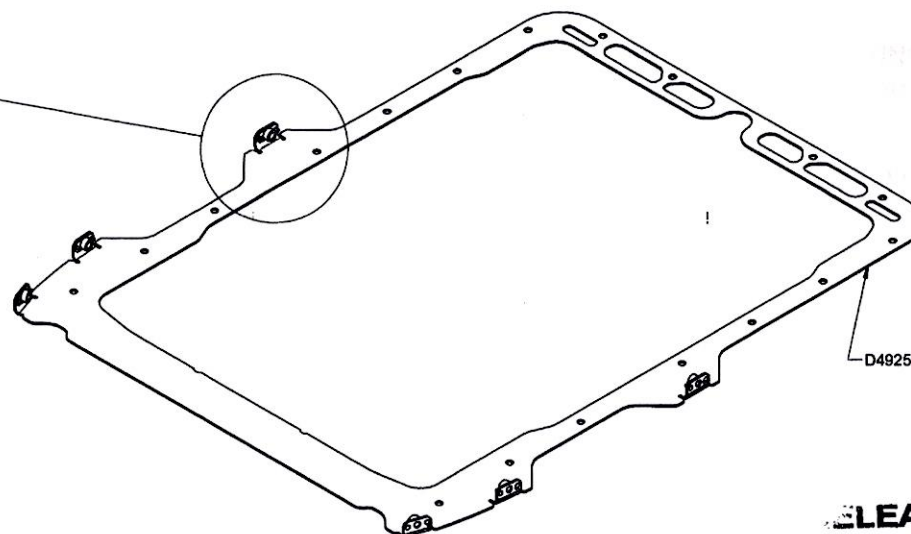
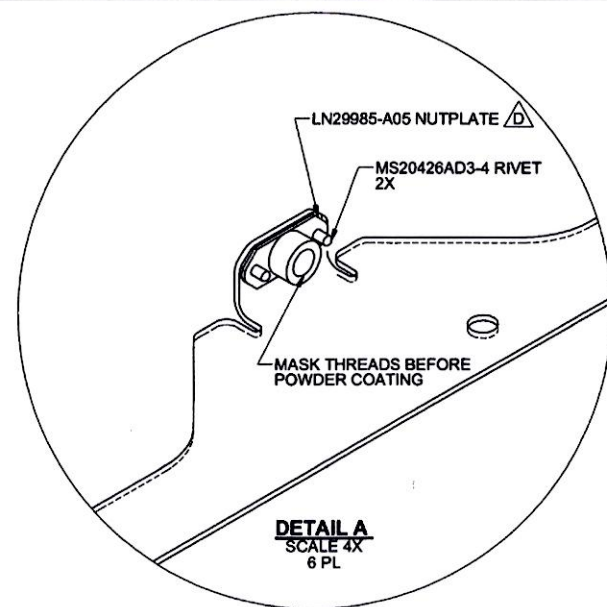
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.098"	✓		tape	
Ø0.250	+0.005/-0.001	0.25"	✓			
Ø0.260	+0.006/-0.001	263	✓			
0.23	+/-0.030	.23	✓			
0.53	+/-0.030	.53	✓			
0.56	+/-0.030	.57	✓			
0.374	+/-0.010	.374	✓			
0.748	+/-0.010	.750	✓			
3.400	+/-0.010	3.400	✓			
6.800	+/-0.010	6.800	✓			
16.14	+/-0.030	16.20/14	✓			
16.73	+/-0.030	16.68	✓			
17.717	+/-0.010	17.713	✓			7.002 under acceptable tolerance
18.58	+/-0.030	18.59	✓			
26.14	+/-0.030	26.14	✓			
10.217	+/-0.010	10.213	✓			
3.406	+/-0.010	3.406	✓			
6.811	+/-0.010	6.814	✓			
3.406	+/-0.010	3.406	✓			
22.69	+/-0.030	22.69	✓			
0.063	+/-0.010	.064	✓			

Measured by:	D	Checked by:		QC Inspector:	
Date:	16.07.18	Date:		Date:	

Engineering Approval: (If necessary)		Date:	
--	--	--------------	--

Rev	Date	Change	Revised by	Approved
A	14.07.14	New Issue	KJ	
B	15.07.23	Dimensions updated per Dwg Rev D	KJ	

ITEM	QTY	P/N	DESCRIPTION
	X	D4925-041	EAPS MOUNTING PLATE ASSY
1	1	D4925-1	EAPS MOUNTING PLATE
2	6	LN29985-A05	NUTPLATE (LN29985-AM5)
3	12	MS20426AD3-4	RIVET, CSK

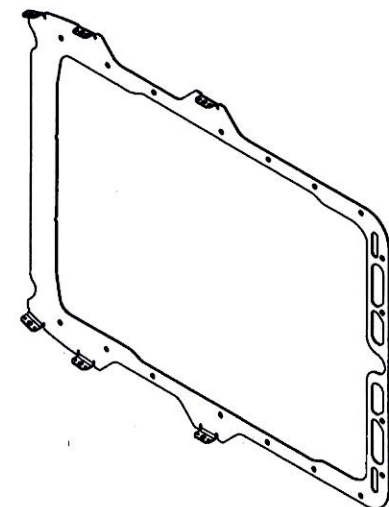
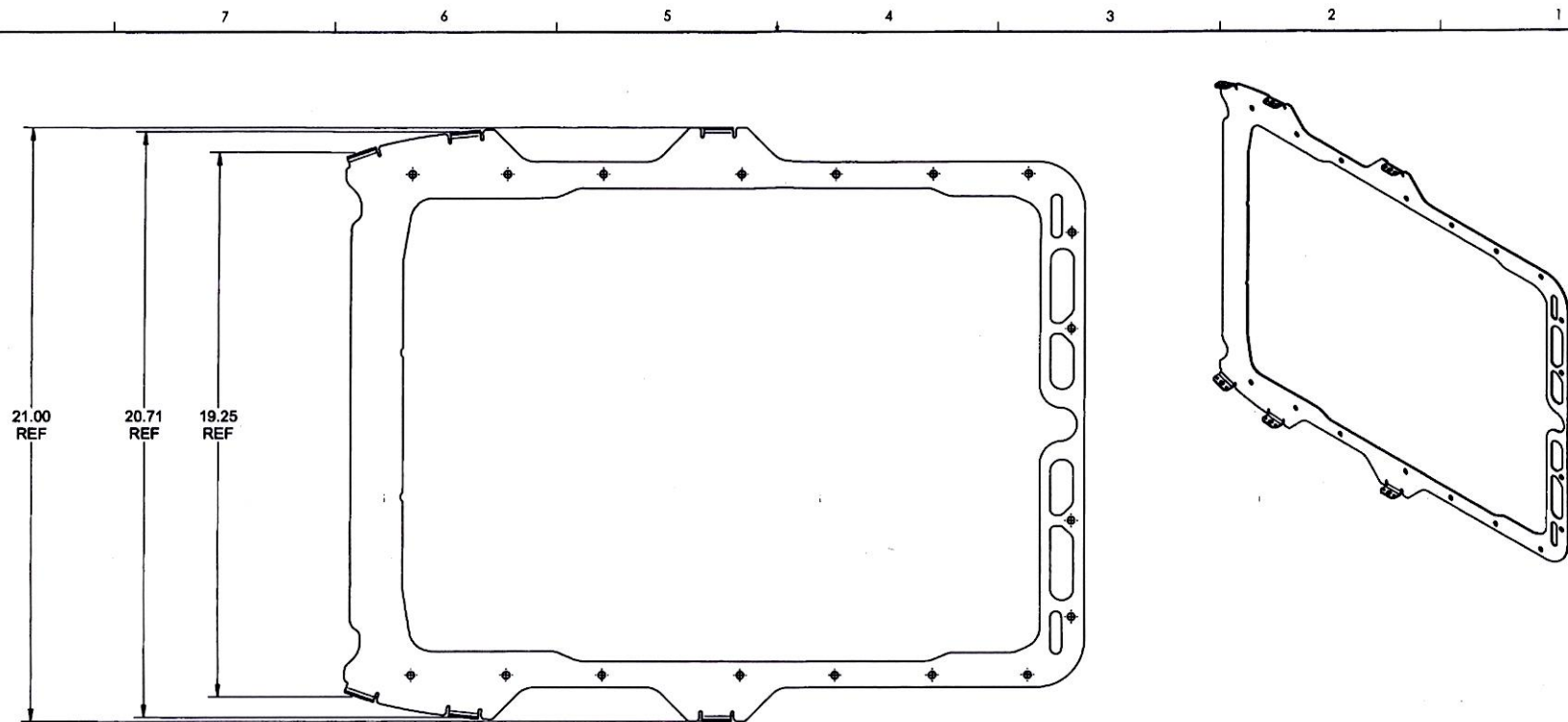


D4925-041 EAPS MOUNTING PLATE ASSY

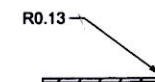
RELEASED
2015 JUN 16
ECN 15-527

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "BLACK GLOSS" (4.3.5.13) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4925-041" PER QSI 044 6.1
 - 7) WEIGHT: 0.27 LBS

REV.	DESCRIPTION	BY	DATE
D	UPDATED BOM (LN29985-A05 WAS MS21059L3), REVISED DETAIL C; ZN 82-3	AK	15.03.08
C	REMOVE SLOTS (5 PL) AND EDGE SCALLOP DETAIL	DB	14.04.04
B	COMPLETE RE-DESIGN, SEE REV A FOR DETAILS	DB	14.01.15
A	NEW ISSUE	DB	13.10.01
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4925	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	EAPS MOUNTING PLATE	NTS
DATE	15.03.06	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D4925-1 EAPS MOUNTING PLATE
(MAKE FROM D4925-1F)



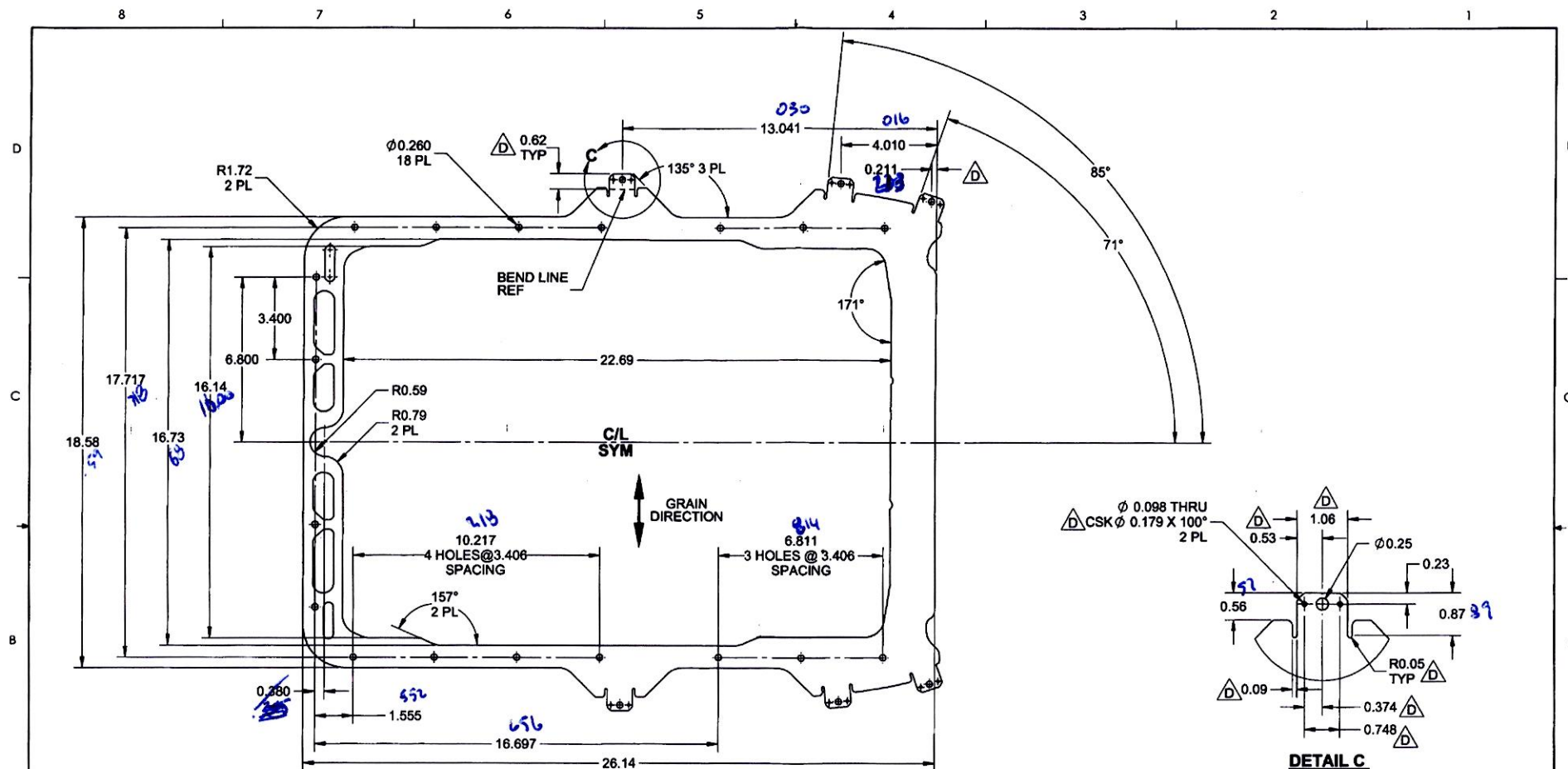
SECTION B-B
SCALE 2X

RELEASED
2015 JUN 16

- NOTES:**
- 1) MATERIAL: MAKE FROM D4925-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A

APPROVED

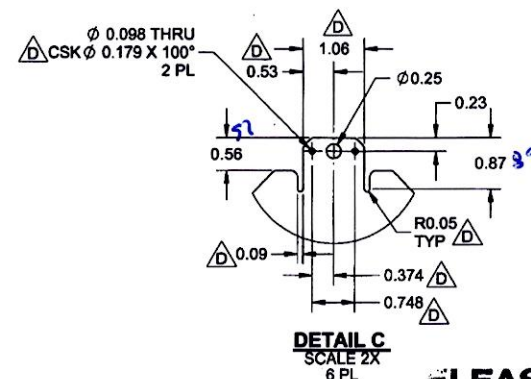
DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4925	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	EAPS MOUNTING PLATE	NTS
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D4925-1F EAPS MOUNTING PLATE

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 0.063 THICK
REF DART SPEC M6061T6S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT 0.26 LBS
- 8) ALL NON-DIMENSIONED FEATURES CONTROLLED BY CAD FILE "D4925-1F Rev D.DXF".



DETAIL C
SCALE 2X
6 PL

RELEASED

2015 JUN 16

APPROVED	DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	DB		
	CHECKED	RF	DRAWING NO. D4925	REV. D
	MFG. APPR.	JLM	SHEET 3 OF 3	
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	EAPS MOUNTING PLATE	NTS
DATE		15.03.06		

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2.051

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32646

Purchase Order Date 6/8/2016

PO Print Date 6/8/2016

Page Number 4 of 12

Order From :

VC-TPI001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

TPI INDUSTRIES INC.
148 RUE GOODFELLOW
DELSON, QUEBEC J5B 1V4
CANADA

Contact Name

Vendor Phone 450-633-0484

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB Destination-Collect

Line Total: \$216.00

9 D4925-1P ✓ EAPS Mounting Plate

6/22/2016

Yes

6/22/2016

18.00 ✓
Each

\$34.50

\$621.00

CUT AS PER DWG D4925-1 REV. D
B145798
MATERIAL 6061-T6 SHEET .063

Sp 16-7-13

Line Total: \$621.00

10 D4462-3P ✓ Baffle

6/22/2016

Yes

6/22/2016

2.00 ✓
Each

\$46.95

\$93.90

CUT AS PER DWG D4462-3 REV. E
B146940
MATERIAL 6061-T6 SHEET .063

Sp 16-7-13

Line Total: \$93.90

Note:

6/8/2016

TPI Waterjet cutting follow up sheet

wc100131

machine hours	1227h
diamond hours	157h
mixing tube hours	6h
TAJ calibration	13-06-2016

7/0: 3264/6

customer po	part #	Qty	lot #	date done	cut by	quality spot check	Note
dart 32646	d4925-1	18	see mill test	08-Jul-16	GR	Jonathan Lessard Gabriel Rioux	add .002 to the .25 and (26) hole SOME ARE OVAL
dart 32646	d4462-3	2	see mill test	08-Jul-16	GR	Jonathan Lessard Gabriel Rioux	add .002 to the .128 hole
dart 32646	d4463-1	2	see mill test	08-Jul-16	GR	Jonathan Lessard Gabriel Rioux	add .001 to the .098 and the .206 hole
dart 32646	d4463-7	2	see mill test	11-Jul-16	GR	Jonathan Lessard Gabriel Rioux	
dart 32646	d4463-13	2	see mill test	11-Jul-16	GR	Jonathan Lessard Gabriel Rioux	

Opérateur



Superviseur



8/16-7-13.